

Mitchell's Mausers

Owner's Manual for the Care and Use of



**The Crown Jewel of
Bolt Action Rifles!**

The Legendary . . .

Mauser 98k - Model 48 Rifle in 8mm Mauser Caliber

This Owner's Manual should always accompany the rifle and be transferred with it upon change of ownership. Become thoroughly knowledgeable with the instructions contained here and review the entire booklet each time you intend to use your rifle.

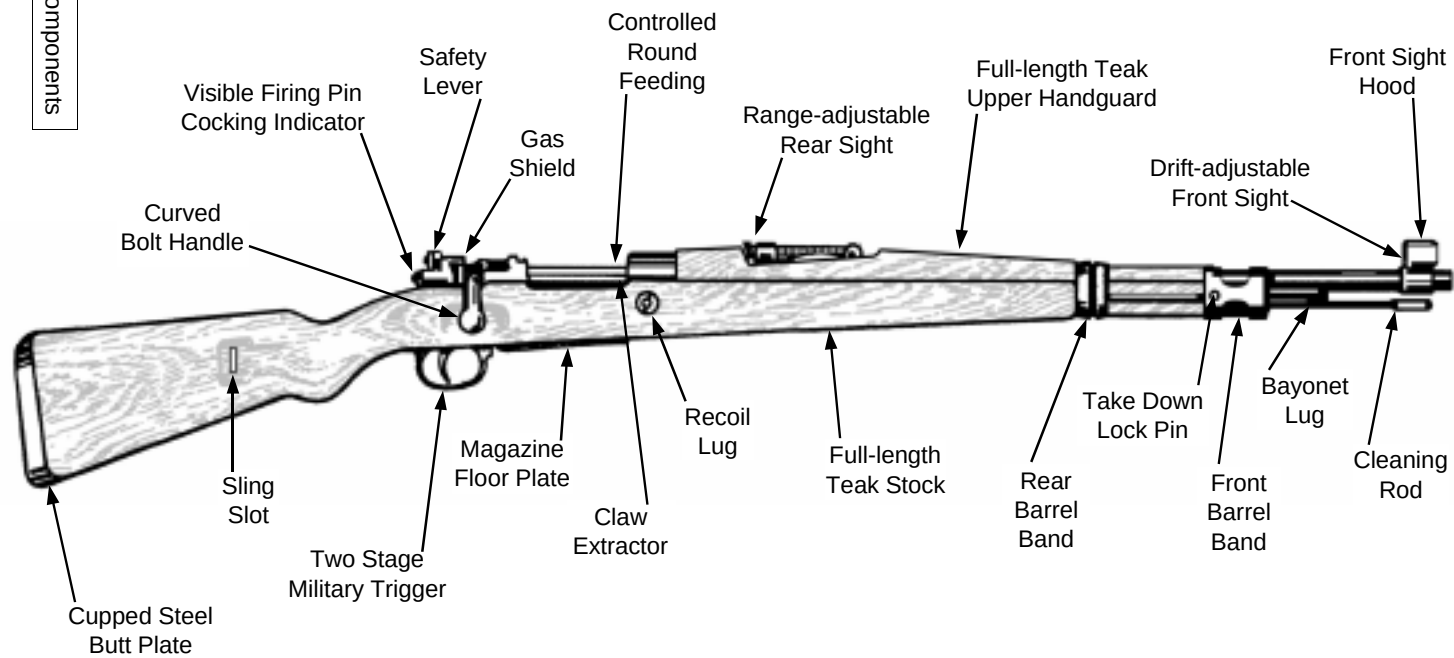
This rifle must be thoroughly cleaned before use.

Copyright© 1999 by Mitchell Manufacturing Corp. All rights reserved.

Fig 1 - Exterior Components

Mauser 98k - Model 48 Parts Identification

This illustration is intended to identify all exterior component parts for easy reference as you go through this owners manual in detail.



Mauser 98k - Model M48

Congratulations . . .

on your purchase of a very special rifle. The rifle you have is more than 50 years old and, at the same time, is a like-new . . .

Collector Grade Rifle!

Your rifle has matching serial numbers on all numbered parts of the rifle. This is rare in the history of gun collecting and especially so in former military rifles. It is very important in establishing the value of your rifle (for insurance or perhaps trading purposes).

Your rifle has its front sight hood in place and its standard issue cleaning rod in place. Please see also the accessory listing located near the end of this manual to see just how unique your 'new' rifle really is!

Your rifle is unique among all Mausers. It has a teak stock and teak upper handguard.

Some models come with all accessories that were issued to the soldier at the time. Your rifle never saw actual military service, but it was ready.

You own a great piece of history.

CONTENTS

A Little Mauser History.....	4
Characteristics and General Description	5
Safety.....	6
Safety Lever Functions	6
Loading	8
Sights.....	8
The Correct Sight Picture.....	9
Trigger.....	9
Firing	10
Government Safety Warnings.....	10
Cleaning Your Rifle	
Disassembly	11
Reassembly.....	16
Original Accessories Included.....	17
Modern Optional Accessories	19
Specifications.....	Back Cover

Mitchells Mausers

A Little Mauser History:

Much has been written about the genius of Paul Mauser and his brother Wilhelm and their invention of the famous Mauser rifle. It is the forerunner of virtually every modern bolt action rifle made in the 20th Century. Many books have been written about Mauser rifles. Even today, most bolt action rifles are based on the principles of the Mauser brothers, regardless of the brand.

Your rifle is a Mauser 98k Model 48 rifle that was built near the end of W.W.II and, as a result, it never saw actual military service. It was manufactured and held in reserve for reserve forces in the event of renewed hostilities. The production of semi-automatic and full-automatic rifles in Europe then rendered bolt action rifles functionally obsolete for the main body of an army. During the last 50 years your rifle was removed from storage, cleaned, tested and restored to storage, every five years; to insure its combat readiness. Fortunately, active service was not



necessary for your rifle.

Your rifle is in near-new condition and shows only 'garrison marks'. These are handling and storage marks accumulated over the years together with the preservatives of the day that, in some cases, tended to change the hue and wear of the bluing. Over the years the preservative affected the color of the wood in different ways so that no two rifles are exactly alike.

So, your rifle was recently 'honorably discharged' from the military and is now a civilian! The Model 48 rifle is a very strong rifle, originally designed for the rigors of combat. As such it provides you with an excellent platform for sporterizing or you can use it for hunting just as it is (but please leave the bayonet at home). It's 8mm Mauser caliber is ballistically similar to our .30-'06 Springfield.

It is a functionally new rifle. It has preservative in it and on it.
Before use, it must be thoroughly cleaned and examined by you.

Mauser 98k - Model M48

You must assure that the rifle is clean, complete and normally functional as described in this manual. Please pay particular attention to the section on cleaning your rifle.

As an owner, that responsibility rests with you.

Characteristics and General Description of your Rifle:

The Mauser 98k Model M48 is a shoulder mounted, trigger actuated, striker fired, magazine fed, bolt action rifle. It is designed to be fired from the shoulder only; not in any other position, whether standing, sitting or prone.

The rifle is equipped with features that were standard for the time and are still considered 'advanced' today. It has, for example, 'controlled round feeding', a long, heavy claw extractor, two heavy-duty front locking lugs and an additional safety lug built into the rear of the bolt. It also has a superb gas shield. The long claw extractor serves as a bolt guide along with a built-in bolt guide that is built into the body of the bolt. The bolt body has gas escape ports to handle cartridge failure. It is generally accepted that it has the best safety mechanism ever designed. Your rifle is quite possibly the strongest bolt action rifle ever built.

Your rifle is now a 'civilian' and, as such, is perfect for collecting, target shooting, big game hunting, or sporterizing. **It is a rarity** because of its like-new condition for its age.

Note: Some rifle models come with the original leather accessories including a sling, ammunition pouch and belt hanger for the bayonet scabbard. The leather is 50 years old and has varying degrees of color and age marks. You can easily make it look like brand new with any good commercial leather cleaner, shoe polish or leather preservative.

Some models of your rifle come equipped with an original bayonet and scabbard and an original military field cleaning kit. Your rifle was once a complete battle ready 'soldier'; it is now a 'civilian' and the bayonet and scabbard are **purely decorative items for display purposes** and attest to the authenticity of your rifle.

Mitchells Mausers

Safety:

Safety is your responsibility and your primary concern. Of course, you know the basic handling rules governing the use of any firearm. Nevertheless, we repeat them here:

1. Never point this rifle at **anything** you are not willing to destroy, even if it is not loaded. This rifle fires the powerful 8mm Mauser cartridge. You must know what you're doing.
2. Don't load or fire this rifle until you are thoroughly familiar with it and all of its handling characteristics. If you don't understand something or need to ask a question, please call us.
3. Don't handle or clean this rifle without assuring yourself and those around you that the rifle is empty and safe.
4. Don't load it or shoot it until you have examined it completely and know that it is clean, complete, safe and fully functional.
5. Don't put or keep a live round in the chamber unless the safety is on.
6. If you have been drinking or have been using any drugs, prescription or not, put the rifle away and come back another day. You won't perform to the standard of the rifle, you could get in trouble or, worse yet, hurt yourself or someone near you.

This Rifle is NOT a Toy. Be Careful.



Safety Lever Functions:

Your rifle has one of the most advanced safety mechanisms in existence, even today. It is generally recognized that no other rifle safety is as good, no matter the brand or the cost.

The safety lever is located on the top rear of the bolt. It has three positions; full left, middle and full right.

Mauser 98k - Model M48

1. **Fully safe position:** Same as the 'full right' position. With the lever easily swung over to the full right position, the rifle cannot be fired, and the bolt cannot be opened. The rifle is fully safe.
2. **Safe-unload position:** Same as 'vertical' or 'middle' position. With the lever standing straight up, the rifle cannot be fired but the bolt can be opened for unloading. If you change your mind and choose not to shoot, you can safely unload your rifle without putting it in the fire position (unlike many newer designs). If you attempted to fire your rifle in the 'safe-unload' position, you would quickly see that the vertically standing safety lever would interfere with the sights and at the same time, the trigger is disabled! You have an advanced hunting rifle, even by today's standards!
3. **Fire position:** Same as 'full left' position. With the safety lever in the full left position, the rifle is ready to fire. **It will fire if the trigger is pulled.**

As an added feature, you can tell if your rifle is 'cocked' by just looking at it; without even picking it up! Just look at the rear of the bolt and see how far the firing pin base protrudes rearward from the gas shield. If it protrudes about a half inch, you **know** it is cocked, so be extra careful. If it protrudes only one quarter inch, you know it is not cocked. The difference is easy to see or even feel, in the dark.



1. Right: Safe & Locked



2. Vertical: Safe & Unlocked



3. Full Left: Fire

Caution: A decocked rifle with a live round in the chamber is NOT a safe condition. An accidental blow could fire the rifle. **Always use the safety lever**

Mitchells Mausers

Loading:

There are two ways to load your rifle. Put the safety lever in the straight up (middle) position before you do anything.

1. The fastest way to load is to have ammunition on 'stripper' clips. Notice that there is a cut-out in the top rear receiver ring designed specifically for stripper clip loading. With the bolt open, simply fit the loaded clip into the cut-out and then smartly 'strip' the cartridges into the empty magazine as far as you can push them. There is a cutout provision in the left rear of the receiver to allow room for your thumb to push the cartridges down into the magazine. The stripper clip will then be standing empty. You can lift it out by hand or when you close the bolt, it will be pushed up and out of the rifle.
2. The simplest way is to simply open the bolt and push cartridges into the magazine, one at a time. Simple, fairly quick, and very easy.

You should practice with the safety lever until you are comfortable and sure of its' three positions and how the different positions affect the rifle. When Paul Mauser designed the rifle, he successfully designed it to be 'soldier proof' (which really means combat-ready). You are holding one of the most copied designs in the firearms world! Your rifle is extraordinarily rugged, very accurate, and a joy to own..

Sights:

The sights of the rifle are adjustable from one hundred meters all the way out to 2,000 meters! In one hundred meter increments. At its rear-most setting the sight is set for one hundred meters. This is an ideal setting for hunting with open sights. For longer ranges, the sight can be adjusted simply by squeezing the two locking lugs together and sliding the sight up its ramp to the desired distance. At ranges beyond 200 yards, the rifle and the cartridge will perform admirably well, **but you won't**. The human eye just can't cut it for game animals or silhouette shooting without optical assistance at that distance.

The front sight provides you with 'windage adjustment'. In reality you'll use "Kentucky windage" once you set the front and rear sights in the way you like them for the particular style and weight of hunting bullet you are using. To adjust the front sight you must first remove the front sight hood. (Before that, take the bolt out of the rifle.) The hood can only come off by pulling it forward because it rides in two grooves in the front

Mauser 98k - Model M48

sight base. With the hood removed, the drift adjustable sight is exposed. Lay the rifle down on its side and support the front sight base securely because you will be 'tapping' on the sight alone; to move it in its groove. It is a dove tailed friction fit and it will not move easily. However, not much movement will be required to make even large adjustments. Movement of the sight should only be done by using a small brass tool(rod) and tap the rod with a hammer using only light blows. **Be sure of what you are doing.** Do not scar or damage your rifle.

To move the impact point to the left, move the front sight to the right. To move the impact point to the right, move the front sight to the left. Just remember that slight movement of the sight means a lot of movement of the impact point out at 100 meters. Your rifle will be very accurate right out of the box. Do not adjust windage unless really necessary.

We suggest you limit yourself to what is comfortable for your eyes as far as distance is concerned. If you're tired, boozy or distracted, forget about shooting. Come back when you're alert, focused and ready to perform up to the ability designed into your rifle.

The Correct Sight Picture:

The rear sight has a 'V' notch, and the front sight has an inverted 'V' post. Simply match them up and make sure they are level and centered; the front in the rear and level. That forms the correct sight picture. The inverted 'V' post centered in the rear 'V' notch of the rear sight is the correct (and only) sight picture you should use.



Trigger:

Your rifle has a two stage 'military' trigger designed for safety and reliability. It requires that you practice with it to know it well. Its first 'stage' is simply a take-up stage and the second stage is the firing stage. You'll feel the trigger come to a definite firmness after you take-up the first stage and as you feel the firmness, you feel the trigger 'break', firing the rifle. To be as accurate as the rifle, you must learn the trigger and know when it will fire. It is simple and easy to learn but it does require practice. If you shoot for group size, trigger control is paramount. Your rifle will perform, but only as well as you are able to hold it.

Mitchells Mausers

Firing:

Your rifle is designed to fire only the 8mm Mauser cartridge. It is readily available and can be purchased where you bought the rifle.

Your rifle is a shoulder fired rifle and requires the use of two hands. It should not be fired in any other way. Grasp the semi-pistol grip in your right hand, and with your left hand, grasp the rifle as far forward as is comfortable for you. Bring the buttstock firmly to your shoulder and as high as is comfortable. You want to get a secure 'weld' between the stock and your cheekbone. In this way you have full control of the rifle and will be the most accurate. Remember, control is everything.

You must be certain of your target before you shoot. You must know where your bullet will go before you shoot; even if you miss, because you can't call it back. Your bullet is very powerful and, depending on the type you choose to use, can have very high penetrating characteristics. You must be sure of the backstop for your bullet because you may shoot right through your target and hit something you weren't intending to hit.

Hit or miss, the responsibility is yours. Be sure of what you are doing.

Government Safety Warnings:

WARNING

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposures to lead and other substances known to the State of California to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

NOTICE

If you leave a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison or both.

In light of everything contained in this manual, keep three things in mind:

- 1. Be safe!**
- 2. Be careful!**
- 3. Have fun!**

Mauser 98k - Model M48

Unloading Your Rifle:

If you change your mind and choose not to shoot, just follow these simple instructions. Keep the rifle pointed safely down range. Raise the safety lever to the vertical position. (If the rifle is not cocked, lift the bolt handle first, then put the safety on.) Open the bolt and extract the loaded round. If there are cartridges in the magazine, you may unload the magazine by cycling all cartridges with the bolt while the safety lever is still in the vertical position. Just cycle the bolt for as many cartridges as remain in the magazine till the magazine is empty.

Cleaning Your Rifle:

Your rifle has fifty years of preservative in it and on it. It must be thoroughly cleaned before use.

Disassembly:

1. Unload your rifle and remove all ammo from the area.

2. Remove the Bolt. (Rifles are shipped with the bolt already removed.)

Point the rifle in a safe direction. Put the safety lever in the vertical (upright) position. (If the rifle is not cocked, lift the bolt handle first, then put the safety on.) Open the bolt and pull it to the rear. It will stop against the bolt-stop.

On the left side of the rear part of the receiver is a spring loaded, hinged, release lever, which will release the bolt stop. It swings from the front, being hinged in the rear. Swing it all the way out and that will allow you to pull the bolt out of the rifle.

3. Remove the Magazine Floor Plate and Follower.

- a. Turn the rifle upside down so that you can see the magazine floor plate. At the rear of the floor plate, near the trigger guard you will see an opening that provides access to a small, spring loaded plunger. To remove the floor plate, use a brass rod that is about the size of the little button plunger and fully depress the plunger as far as it will go, about 1/8th inch. While holding the plunger depressed, slide the

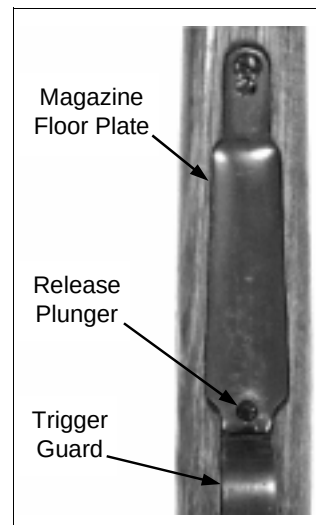


Fig 2 Magazine Floor Plate.

Mitchells Mausers

floor plate and the rod firmly rearward. The floor plate will move back about 1/8th inch only.

- b. Release the pressure on the plunger and the floor plate will come away from the rifle by the force of the follower spring. Lift out the whole assembly as one piece, the floor plate, the follower and the follower spring. (We'll take it apart later.)
- c. Now thoroughly clean out the magazine well with a good quality solvent. Wipe clean the inside of the receiver (where the bolt goes) with solvent and make sure there is no trash or shipping material residue anywhere in the receiver or magazine well.
- d. Take the follower assembly apart for cleaning. Simply slide the flat spring out of the base of the follower and slide the other end out of the top inside of the floor plate. (Thou shalt pay close attention to what thou art doing as the spring will go back into the floor plate and the follower in only **the same way** they came out.) If you put it back together wrong, the follower may jam the cartridges during feeding and that is a bummer (it could also be dangerous!). Make sure you do it right! After you've cleaned all three parts, you can re-insert them into the rifle.

4. Clean the Barrel Thoroughly:

Use a good solvent and keep going at it until you get a clean patch through the barrel. Change patches every time; use one patch one time only. Look through the barrel from the breech end and the barrel should be sparkling clean with the spiral grooves clean and sharp! This is a tribute to the quality of your rifle. The cleaning rod under the barrel is screwed into position. It alone, is too short to clean the barrel. Soldiers, together, screwed two rods together, to make one long one and then cleaned both rifles as the rod is too short by itself. We suggest you simply buy a one piece rod to clean the barrel and leave the original one screwed in tight, right where it is (and where it belongs).

5. Clean the Receiver.

Thoroughly clean the trigger sear, the locking lug recesses, the slide-ways and all of the surfaces inside the receiver.

6. Disassemble and Clean the Bolt:

The preservative grease inside the bolt will cause the rifle to fail to fire. To clean the bolt, you must become knowledgeable about its disassembly and reassembly. You may require some help here as this is

Mauser 98k - Model M48

somewhat difficult (it requires some strength in your hands and you are dealing with a very powerful firing pin spring, **so pay careful attention**).

- a. Check the position of the safety lever. It should be in the vertical (upright) position. If it isn't, put the bolt back in the rifle and close it. Swing the safety lever up to the vertical position. Then remove the bolt from the rifle and proceed.
- b. Separate the firing pin assembly from the bolt body as follows. Observe the small spring loaded plunger on the rear of the bolt opposite the bolt handle. It is the Bolt Sleeve Lock Plunger. Grasp the bolt in your left hand and with your left thumb, push in the plunger. With your right hand, grasp and turn the whole rear assembly counter clockwise. After one or two complete turns, the rear assembly will turn easily without pressure on the locking plunger. Unscrew the assembly and lift the firing pin assembly out of the bolt body. You will likely find it covered with protective grease, which would likely cause a failure to fire. Soak both the entire empty bolt body and the firing pin assembly in solvent.
- c. Notice that the bolt body has two gas vents in the bottom of the bolt body. These serve two purposes. First, they serve as the primary gas escape holes in case of a cartridge failure and second, they are two lubrication ports giving you access to the whole bolt internally because you won't want to take it apart very often.
- d. Clean the bolt body:
 - i. Swab the interior of the bolt body. Make sure there is no dried grease left inside.

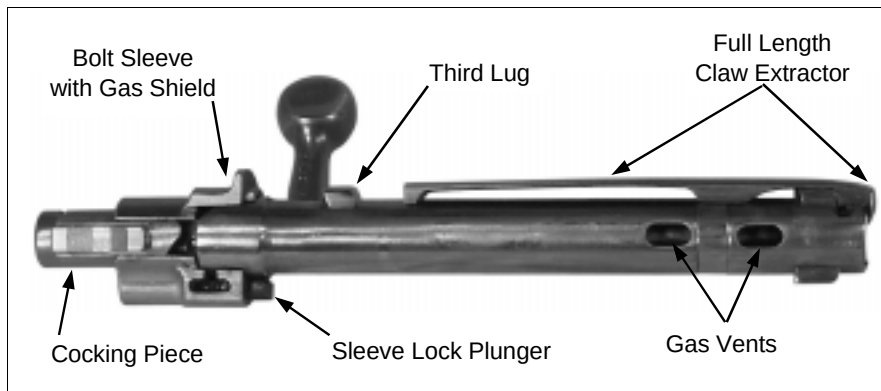


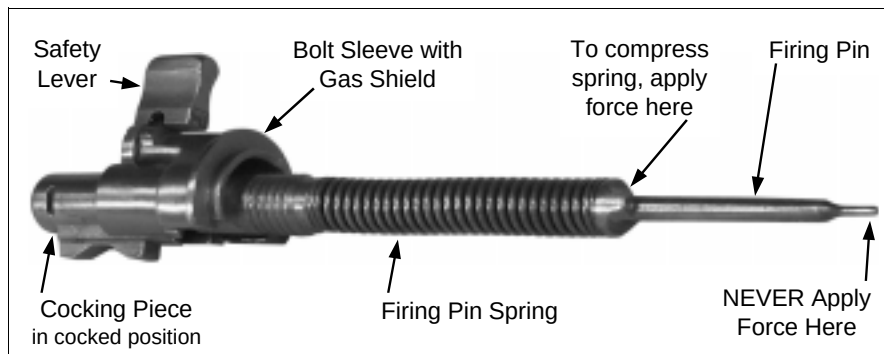
Fig 3. Bolt Assembly, Bottom View.

Mitchells Mausers

- ii. Clean all of the little nooks and crannies. A tooth brush is handy. Carefully inspect everything.
- ii. Observe the long claw extractor. It should easily rotate around the bolt through the full range of its guide slot. Do not remove the extractor. Simply clean it. Restore it to its original position in line with the locking lug, otherwise you won't be able to get the bolt back into the rifle.
- e. Clean the Firing Pin Assembly:
Notice that the firing pin is in cocked position, the very powerful firing pin spring being compressed and held in position by the safety lever. Do not attempt to release the safety. Normally this assembly can be cleaned without further disassembly. Soak the assembly in solvent and then wipe, brush, and blow it clean.

Further disassembly is difficult and not normally necessary. Also there is some risk of bending the firing pin. Skip the following italicized steps unless you have a real reason to completely disassemble the Firing Pin Assembly.

- f. *Disassemble the Firing Pin Assembly, which consists of the Firing Pin, the **highly compressed** Firing Pin Spring, the Bolt Sleeve, and the Cocking Piece.*
 - i. **Caution:** Notice that the firing pin protrudes about 2" beyond the front of the compressed spring. **Be careful not to bend it when compressing the spring.** Do not apply force to the tip of the firing pin. It is best if you have a work table or a block of wood with a small hole into which the front of the firing pin will fit, right up to the squared off enlarged portion just in front of the spring. (If this is not available to you, do not proceed.)



Mauser 98k - Model M48

- ii. **Caution:** From this point on you will be dealing with a highly compressed and powerful spring. **You must wear eye protection.** If you don't have it, stop the procedure until you get eye protection because you will be decompressing and compressing the spring (in the re-assembly process).
- iii. *Compress the spring:* With the firing pin inserted into the work table hole, firmly grasp the bolt sleeve while leaving the cocking piece free to move. This takes considerable pressure and strength. Exert downward pressure on the bolt sleeve, compressing the spring until the cocking piece can be freely turned 90 degrees in either direction (you may well need some help here).
- iv. *Remove the cocking piece:* With the cocking piece turned 90 degrees, you can slowly relax your downward pressure on the spring tension and the whole assembly will come apart. Note which side of the firing pin is up, so you can reassemble it the same way. The firing pin and its spring will come apart (you can see how powerful it is) as well as the bolt sleeve and safety lever. Swing the safety lever over to full right (otherwise it won't come off) and then pull it straight back. It will come right out.
- v. *Now you can clean everything in detail.* You won't want to disassemble the bolt too often (for obvious reasons). You can see that the firing pin and its spring live deep inside the bolt body so you want a light film of oil over the entire surface of all parts; especially inside the bolt body. Never use grease inside the bolt, it could cause a failure to fire.
- g. *Re-assemble the firing pin assembly.*
 - i. *Insert the safety lever into the bolt sleeve with the lever going in at the full right position (otherwise it won't go) and then swing it up to the vertical position and keep it there during bolt assembly. The vertical safety position is necessary for bolt assembly, and in that position it can be used as an additional surface to apply force when compressing the firing pin spring in the next step.*
 - ii. *Put the firing pin spring back onto the firing pin and put the firing pin tip into the worktable hole. Slide the bolt sleeve assembly over the rear of the firing pin. It can go on only two ways, because the firing pin has flat sides. We suggest that you should always re-assemble it with the same side up.*
 - iii. *While you hold the spring almost fully compressed, install the cocking piece over the firing pin. It too will slide on two different ways, but after you rotate it to lock it on, the sear must be oriented so that it slides into the corresponding slot in the bolt sleeve.*

Mitchells Mausers

- iv. *Make sure the safety lever is in the vertical position. If it is not, compress the spring again and turn the safety lever to the vertical position. The bolt is now 'cocked' because the spring is compressed and ready for installation into the bolt body.*

Now that you have seen some of the internal parts, you can appreciate the superior engineering and extra strength built into your rifle. Now you can begin the reassembly process.

Reassembly:

1. Reassemble the bolt: Make sure the firing pin assembly is 'cocked' with the safety lever in the vertical position. Insert the firing pin assembly into the bolt body and turn it clockwise until the bolt sleeve stop plunger engages the bolt body and prevents further rotation. On the one or two final turns, it may be necessary to compress the plunger so it will clear the bolt handle.
2. Re-install the Magazine Follower Assembly. Fit the follower through the magazine well. Notice that the front of the floor plate has a lip cut into the leading edge. This lip will fit into the front of the lower edge of the magazine well when assembled. There is a similar arrangement at the rear of the floor plate around the plunger hole. To assemble it, position the floor plate slightly to the rear of the assembled position, press down on the rear of the floor plate to compress the plunger, and slide the floor plate forward so that both the front and rear lips of the floor plate engage the slots in the magazine well. The plunger should spring into the hole in the rear of the floor plate, thereby locking the floor plate in place. Only moderate pressure is required to do so.
3. From the top, make sure the follower is in position and moves up and down freely. It's job is to lift cartridges so it must be free.
4. Re-insert the bolt assembly into the rifle. Make sure the claw extractor is lined up with the right-hand locking lug, or it will not go in. Confirm the proper working of all functions: bolt open and close, safety lever in all positions, and trigger.
5. Wipe all sections of the rifle free of preservative grease in and around the rear sight and the forward metalwork. Carefully wipe away all preservative grease and lay on a thin film of oil; even on the wood.

Among famous rifles, your Mauser is a Crown Jewel!

Mauser 98k - Model M48

Original Accessories Included:

Some rifles come equipped with all the accessories intended for soldiers over fifty years ago.

1. **Bayonet, Scabbard, and Frog.** Your rifle comes with a standard issue bayonet and scabbard. The bayonet is brand new (but over fifty years old) and is **very sharp**.

The frog (the leather belt hanger) is a safe way to carry a bayonet, should you choose to do so. The frog stud on the side of the scabbard fits into the small hole in the frog (yes it will fit, but it will be a bear to remove). The bayonet fits into the scabbard, and the strap on the frog goes around the hilt of the bayonet. Easy to get to and you won't lose it. **Check local laws before carrying your bayonet.**

Although you could theoretically use your bayonet for some practical purpose, its main purpose now is for display and collecting.

It is original to your rifle and has a unique historical value because it is unused. Keep it that way.

- 2 **Field Cleaning Kit:** The field cleaning kit consists of a bag containing an original metal oil can, a standard issue cleaning rope, a bore brush, and the steel bore guide.

Perhaps the rarest accessory included with your rifle is the spring loaded bore guide. This item is rare in Mauser collecting. It is designed to fit directly over the muzzle of the rifle and hooks directly and securely behind the front sight base. It protects the muzzle crown from inadvertent damage with cleaning rods. **Never fire the rifle with the bore guide in place**, because you can do serious damage to the rifle muzzle or worse, injure yourself or those around you.

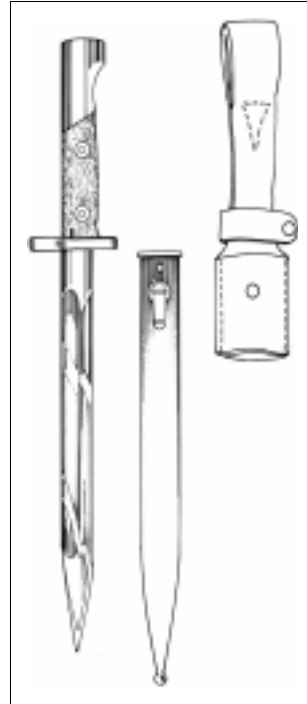


Fig 5. Bayonet with Scabbard and Frog



Fig 6. Cleaning Kit

Mitchells Mausers

A cleaning rope is something we don't see very often any more. The rope is small enough to easily pass through the bore. Each end has a lead weight so it can be easily dropped through the bore. In the middle is a loop that is designed to hold a swab soaked in oil or solvent. You'll probably want to keep the cleaning rope in its original condition for its historical interest.

3. **Leather Shoulder Sling:**

The sling has two important devices associated with it to make it function properly. The first is a sling keeper, which is a metal plate covered with leather with a brass stud, designed to hold one end of the sling and keep it from slipping through the slot in the stock. The other device is a simple brass stud that is used to attach the sling to itself to make an adjustable loop at the forward end.



Fig 7. Sling with keepers

To install the sling, proceed as follows: First, install the sling keeper on the rear end of the sling, the end with fewer holes. Insert the end of the sling through the keeper from the bottom, insert the tip of the sling under the strap, and then work the hole in the leather down over the stud as depicted in Fig 7. Then run the sling through the slot in the stock so that the keeper ends up on the right side, nestled into the recess in the stock. Finally, run the loose end of the sling through the sling attachment loop in the left side of the rear barrel ring. Adjust to desired length and secure with the brass stud.

You can carry the rifle with the sling or use it as a very good shooting brace, if you choose.

4. **Cartridge Pouch:** A leather double ammo pouch that will conveniently hold a box of ammo in each side and can easily be carried right on your belt. Fig 8.

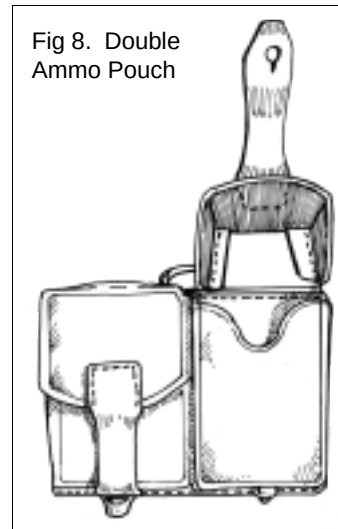


Fig 8. Double Ammo Pouch

Mauser 98k - Model M48

Modern Optional Accessories:

You may now purchase the following newly designed accessories for your rifle. They will permit you to selectively “modernize” your rifle for hunting purposes and then restore your rifle to its original military configuration any time you please.

1. **Long eye-relief scope mount:** This mount fits securely into the base of the rear sight and requires no gunsmithing. You can do it yourself and you won’t alter your rifle. Just follow the detailed instructions that come with it. It replaces the ranging ladder in the rear sight, and you can restore the ladder at any time.
2. **Long eye-relief scopes:** Two models, actually. One is a fixed 4 power scope and the other is a 2x7 power variable. Either one will fit the new scope mount and give you long range capability. Only the very newest rifles made today utilize this long eye-relief system, but your rifle was designed for it more than fifty years ago!
3. **Sporting Stocks:**
 - High quality reinforced fiberglass made in the style of modern varmint rifles. It is extraordinarily strong and totally weather-proof. Your rifle action will ‘drop-in’ solidly. Then you can restore your rifle to its original military condition any time you please.
 - Beautiful walnut stock made in a modern sporting design including a cheekpiece as found on better hunting rifles. It, too, is a drop-in model. No fitting is necessary. Just follow the instructions included and you’ll really have two rifles in one; a military collector and a hunter, and you can switch back and forth as needed.
4. **Other Accessories** are constantly being developed and made available to our customers. Contact us.

To purchase any of these extra items, simply contact your local dealer or you may, if you wish, purchase them directly from us.

Mitchell Manufacturing, Inc.
P.O. Box 20855
Fountain Valley, CA 92708

(714) 964-1837
www.MitchellSales.com
CustServ@MitchellSales.com

Mitchell's Mausers

Collector Grade Mauser Rifle

The M48 rifle represents the peak development of the K98 Mauser style infantry rifle. It's superior design incorporated more refinements and it was constructed of superior materials, not having been subjected to material shortages like the rifles built in Germany. Only an accident of history has preserved this fine rifle for your enjoyment.

Your rifle is over 50 years old. It is an heirloom and will last for many generations with just a modicum of care. Keep it clean, keep it oiled and keep it safe from children. **In time, you can pass it on to them.**

Rifle Specifications — M48 Mauser

Action Type:	Large Ring Mauser Bolt Action, Striker fired, Magazine fed, with Long Claw Extractor.
Action Bedding:	Pillar Bedding with locking screws and Cross-bolt Recoil Lug
Magazine Capacity:	5, with Controlled Round Feeding.
Caliber:	7.9mm (8x57JS Mauser)
Bullet Diameter:	0.323"
Barrel Length:	23¾"
Rifling:	4 grooves, right twist.
Rear Sight:	Standard V-notch, adjustable to 2,000 Meters.
Front Sight:	Hooded, inverted V, forming a clean sight picture.
Stock Material:	Oil-resistant Teak Wood
Over-All Length:	42.7" (without bayonet).
Weight:	8.8 lbs.

Mitchell's Mausers
Mitchell Manufacturing, Inc.
P.O. Box 9295
Fountain Valley, CA 92728

(714) 964-1837
fax (714) 979-7238
www.MitchellSales.com
CustServ@MitchellSales.com

Copyright© 1999 by Mitchell Manufacturing Corp. All rights reserved.